



Dart Aerospace Ltd.
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D2873-043

Job Sheet 186552



Part No: D2873-043

Job Qty: 20 ea

Part Name: Nut Plate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/16/18

Job Tracking No:

Due Date: 12/21/18

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG REV A IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	12/21/18	12/21/18	0.00	0.00	Start Up Machining-1		ANML 18/12/18
100	Bandsaw	20 pcs	12/21/18	12/21/18	0.00	0.10	Bandsaw1		FRED 18-12-5
110	CNC Vertical Machining	20 pcs	12/21/18	12/21/18	0.04	5.28	HAAS1-2		FRED 18-12-5
120	QC	20 pcs	12/21/18	12/21/18	0.00	0.00	QC2 Machining-1		FRED 18-12-5
130	QC	20 pcs	12/21/18	12/21/18	0.00	0.00	QC8 Machining-1		18-12-18
150	QC	20 pcs	12/21/18	12/21/18	0.00	0.00	QC5		DEC 17 2018 68
160	HandFinish	20 pcs	12/21/18	12/21/18	0.00	0.25	HandFinish1		D.R 18/12/18
170	QC	20 pcs	12/21/18	12/21/18	0.00	0.00	QC7-1		DAS 36
180	Small Fab	20 pcs	12/21/18	12/21/18	0.00	0.68	Small Fab-2		36 DAS 9-89
190	QC	20 pcs	12/21/18	12/21/18	0.00	0.00	QC5		9-89 38
200	Packaging	20 pcs	12/21/18	12/21/18	0.00	0.00	Packaging3-1	LG 050	AS 18-12-20
210	QC21-SA	20 Ea	12/21/18	12/21/18	0.00	0.00	QC21		DAS 21 DEC 20 2018

Part Op 100 - Cut blanks: 1.000" x 0.375" x 3.700" long

Descriptions: 110 - Machine as per Folio FA and Dwg D2873 Identify as D2873-3 Dwg Rev _____ Folio Rev _____

180 - 1-Assemble as per Dwg D2873 2-Identify as D2873-043

200 - LOCATION : LG050

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X1.000	6061T6 Bar .375 X 1.00	6.1660 ft (.3083 ea)	90-Start up Operation	5122976-5.41
MS20426AD4-6	Rivet	120 Ea (6 ea)	180-Small Fab	5056024-1.00
MS21075L5	Nut Plate	60 Ea (3 ea)	180-Small Fab	5043088-1
				5127335 (180)
				5133199
				5131196 (302)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.375X1.000	6	38	0
180-Small Fab	MS20426AD4-6	120	1,787	0
	MS21075L5	60	260	0



Container No: S133733



Part: D2873-043

Job No: 186552

Serial No/Batch: S133733

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Part Specifications

Specifications could not be found.

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

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